

Date: Tuesday, 24/02/2009 7:57:21 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 46040	
Estimate Number : 13581	
P.O. Number :	Part Number : D38163
This Issue : 24/02/2009 S.O. No. :	Drawing Number : D3816 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 45676	Material :
Written By : <u>09-02-24</u>	Due Date : 03/03/2009 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 08-09-17 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0326 f(s)/Unit Total : 0.6510 f(s)

6061-T6 Round Bar .500"

Batch: M109 369

09/02/26

20 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE Lathe

1- Turn as per Folio FA785 Rev: AA & Dwg D3816 Rev: A

2-Deburr per dwg D3816

09/02/26

20 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/02/26

20 pcs

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 09/02/26

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-02-26

20

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 46040

Part Number: D38163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-26

20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Store*

9/2/26

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



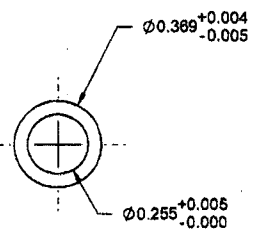
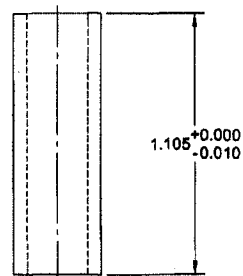
Comment: FINAL INSPECTION/W/O RELEASE

09/03/26

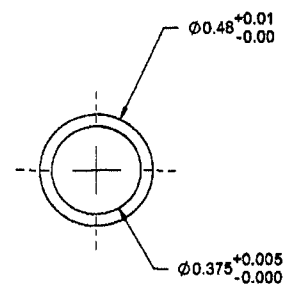
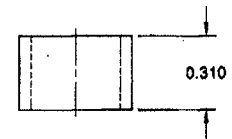
Job Completion



MF
09-02-26



D3816-1 SPACER



D3816-3 SPACER

w/646040

RELEASED
09/13/17

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4180) (REF DART SPEC M8061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3816-1/-3 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3816-1 0.01 lbs
D3816-3 0.01 lbs

A	NEW ISSUE	08.09.17
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.09.17	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3816	REV. A
TITLE SPACER	SHEET 1 OF 1
	SCALE NTS

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